

CLAIMS:

- 5 1. A method of manufacturing a belt, comprising the steps of weaving the belt from a plurality of warp yarns and at least one weft yarn, the belt having a central region and two opposed edges, the warp yarns in the central region having a predetermined shrinkage characteristic, at least one edge region between the central region and an edge of the belt having a predetermined
10 number of warp yarns, each having a lesser shrinkage characteristic than the warp yarns of the central region, the method comprising the steps of passing the weft yarn across the warp yarns to effect a weaving in the central region of the belt, and, in the or each edge region, looping the weft yarn, on each pass, around a selected warp yarn, so that on a plurality of successive passes the weft
15 yarn is looped around each of the warp yarns in the edge region, the method comprising the subsequent step of shrinking the yarns in the belt.
- 20 2. A method according to Claim 1 wherein the shrinking of the yarns is effected by passing the belt through an oven at a temperature of 180°-230°C.
3. A method according to Claim 1 wherein the yarns in the edge region are shrinkable yarns which are partially pre-shrunk.
- 25 4. A method according to Claim 1 where on each successive pass the weft yarn is looped around a different warp yarn, which is not the same as the warp yarn selected for the preceding pass or for the following pass.

5. A method according to Claim 1 wherein, in a series of successive passes the warp yarn is looped around each of the weft yarns in the edge region in a predetermined pattern, with that pattern subsequently being repeated.
- 5 6. A method according to Claim 1 wherein the warp yarns used in the edge region are thinner and lighter than the warp yarns used in the central region.
7. A method according to Claim 6 wherein the warp yarns used in the edge region are substantially 500 Denier (560 dtex) yarns, whereas the warp yarns 10 used in the central region are substantially 1500 Denier (1670 dtex) yarns.
8. A method according to Claim 1 wherein the weft yarn is of a diameter of 0.3 mm or less.
- 15 9. A method according to Claim 1 wherein on each successive pass the weft yarn is looped around a warp yarn which is next or next-but-one to the warp yarn selected for the preceding pass.
10. A method of manufacturing a webbing belt from warp yarns and a 20 monofilament weft yarn, the method comprising the step of weaving the weft yarn with the warp yarns to produce a belt having a central region which is conventionally woven, and having at least one edge region in which the weft yarn, on successive passes, is looped, passes around different selected warp yarns in the edge region.
- 25 11. A method according to Claim 10 wherein the weft yarns in the edge region have a lesser shrinkage characteristic than the warp yarns of the central region, the method including a closing step of shrinking the yarns in the belt.

12. A method according to Claim 10 wherein the shrinking of the yarns is effected by passing the belt through an oven at a temperature of 180°C-230°C.
- 5 13. A method according to Claim 10 wherein the yarns in the edge region are shrinkable yarns which are partially pre-shrunk.
- 10 14. A method according to Claim 10 wherein, in a series of successive passes the warp yarn is looped around each of the weft yarns in the edge region in a predetermined "pattern", with that "pattern" subsequently being repeated.
- 15 15. A method according to Claim 10 wherein the warp yarns used in the edge region are thinner and lighter than the warp yarns used in the central region.
- 20 16. A method according to Claim 10 wherein the warp yarns used in the edge region are substantially 500 Denier (560 dtex) yarns, whereas the warp yarns used in the central region are substantially 1500 Denier (1670 dtex) yarns.
- 25 17. A method according to Claim 10 wherein the weft yarn is of a diameter approximately 0.3 mm or less.
18. A method according to Claim 10 wherein on each successive pass the weft yarn is looped around a warp yarn which is next to the next-but-one warp yarn selected for the preceding pass.
19. A method of manufacturing a belt having a central region and at least one edge region, the method comprising the steps of utilising warp yarns, the warp yarns used to form the edge region of the belt having a different shrinkage

- characteristic to the warp yarns used to form the central region of the belt, such that on shrinkage of the belt, the edge region yarns will shrink less than the central region yarns, the method comprising the further steps of weaving the belt using at least one monofilament weft yarn, and subsequently treating the
- 5 belt to effect shrinkage of the yarns used in forming the belt.
20. A method according to Claim 19 wherein during the weaving of the belt the weft is passed across the warp, to effect a conventional weaving in the central region of a belt and, in the or each edge region, the weft yarn is looped,
- 10 in each pass, around a selected warp yarn, so that on each successive pass of the weft the weft yarn is looped around a different warp yarn, which is not the same as the warp yarn selected for the preceding pass or for the following pass.
21. A method according to Claim 19 wherein on a plurality of successive passes the weft yarn is looped around each of the warp yarns in the edge region.
- 15
22. A method according to Claim 19 wherein, in a series of successive passes the warp yarn is looped around each of the weft yarns in the edge region in a predetermined "pattern", with that "pattern" subsequently being repeated.
- 20
23. A method according to Claim 19 wherein the yarns in the edge region are shrinkable yarns which are partially pre-shrunk.
- 25
24. A method according to Claim 19 wherein the warp yarns used in the edge region are thinner and lighter than the warp yarns used in the central region.

25. A method according to Claim 19 wherein the warp yarns used in the edge region are substantially 500 Denier (560 dtex) yarns, whereas the warp yarns used in the central region are substantially 1500 Denier (1670 dtex) yarns.
- 5 26. A method according to Claim 19 wherein the weft yarn is of a diameter of 0.3 mm or less.
27. A method according to Claim 19 wherein the belt is heat-treated to effect shrinkage of the yarns.
- 10 28. A method according to Claim 19 wherein each successive pass of the weft yarn is looped around a warp yarn which is next or next-but-one-one to the warp yarn selected for the preceding pass.
- 15 29. A method of manufacturing a belt having a central region and at least one edge region comprising the steps of taking a plurality of warp yarns which are to form the belt, the warp yarns to form at least one edge region of the belt having a lesser weight and diameter than the warp yarns used to form a central region of the belt, and weaving the belt using at least one monofilament weft
20 yarn.
30. A method according to Claim 29 wherein, in the edge region, on successive passes of the weft, the weft yarn is looped around a different warp yarn in the edge region, which is not the same as the warp yarn selected for the
25 preceding pass or for the following pass.
31. A method according to Claim 29 wherein on each successive pass the weft yarn is looped around a warp yarn which is next or next-but-one to the warp yarn selected for the preceding pass.

32. A method according to Claim 29 wherein the warp yarns in the edge region have a lesser shrinkage characteristic than the warp yarns of the central region, the method comprising the subsequent step of shrinking the yarns in the belt.
- 5
33. A method according to Claim 29 wherein the shrinking of the yarns is effected by passing the belt through an oven at a temperature of 180°C-230°C.
- 10 34. A method according to Claim 29 wherein the yarns in the edge region are shrinkable yarns which are partially pre-shrunk.
35. A method according to Claim 29 wherein, in a series of successive passes, the warp yarn is looped around each of the weft yarns in the edge region in a predetermined "pattern" with that "pattern" subsequently being repeated.
- 15
36. A method according to Claim 29 wherein the warp yarns used in the edge region are substantially 500 Denier (560 dtex) yarns, whereas the warp yarns used in the central region are substantially 1500 Denier (1670 dtex) yarns.
- 20
37. A method according to Claim 29 wherein the weft yarn is of a diameter of 0.3 mm or less.
38. A belt formed from a plurality of warp yarns and at least one weft yarn, the belt having a central region and two opposed edges, there being at least one edge region between the central region and an edge of the belt in which successive passes of the weft yarn are each looped around a different selected weft yarn in the edge region.
- 25

39. A belt according to Claim 38 wherein each warp yarn in the edge region extends, as an arcuate length of yarn, between adjacent points where that warp yarn is looped by the weft yarn.
- 5
40. A belt according to Claim 38 wherein, in a series of successive passes the warp yarn is looped around each of the weft yarns in the edge region in a predetermined "pattern", with that "pattern" subsequently being repeated.
- 10 41. A belt according to Claim 38 wherein the warp yarns in the edge region are thinner and lighter than the warp yarns used in the central region.
42. A belt according to Claim 38 wherein the warp yarns in the edge region are substantially 500 Denier (560 dtex) yarns, whereas the warp yarns used in the
15 central region are substantially 1500 Denier (1670 dtex) yarns.
43. A belt according to Claim 38 wherein the weft yarn is of a diameter of 0.3 mm or less.
- 20 44. A belt formed from a plurality of warp yarns and at least one weft yarn, the belt having a central region and at least one edge region between the central region and an edge of the belt, the warp yarns in the edge region being thinner and lighter than the warp yarns used in the central region.
- 25 45. A belt according to Claim 44 wherein the successive passes of the weft yarn are each looped around a different selected warp yarn in the edge region of the belt.

46. A belt according to Claim 44 wherein each warp yarn in the edge region extends, at an arcuate length of the yarn, between adjacent points where that warp yarn is looped by the weft yarn.
- 5 47. A belt according to Claim 44 wherein, in a series of successive passes the warp yarn is looped around each of the weft yarns in the edge region in a predetermined "pattern" with that "pattern" subsequently being repeated.